



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D119-796-241
Job Sheet 170328



Part No: D119-796-241

Job Qty: 1 ea

Part Name: Aft Crosstube Installation Without Step (No Hardware)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/15/18

Job Tracking No:

Due Date: 1/19/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Ship Via:

DAS
10
9-89
11N REV F

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/16/18	1/16/18	0.00	0.00	Start Up Crosstubes-1		DO2
120	Packaging	1 pcs	1/16/18	1/16/18	0.00	0.00	Packaging1-1		DP2
130	CNC Bend Crosstubes	1 pcs	1/16/18	1/16/18	4.67	4.17	CNC Bend Crosstube		DAS / BP
140	QC	1 pcs	1/16/18	1/16/18	0.00	0.00	QC15		38
145	Crosstubes	1 pcs	1/16/18	1/16/18	0.00	3.30	Crosstubes-1		GP 9-89
150	Crosstubes	1 pcs	1/16/18	1/16/18	0.00	3.30	Crosstubes-1		GP
160	HandFXtube	1 pcs	1/17/18	1/17/18	0.00	1.28	HandFinish5		CD DAS
170	QC	1 pcs	1/17/18	1/17/18	0.00	0.00	QC7-1		38 DAS
175	QC	1 pcs	1/17/18	1/17/18	0.00	0.00	QC5		9-89 38
180	Outsource	1 pcs	1/18/18	1/18/18			SKY002-VC	39310	MAR 15 2018 9-89
190	Packaging	1 pcs	1/18/18	1/18/18	0.00	0.00	Packaging2		DAS 18/03/15
200	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		38
230	SprayPaint	1 pcs	1/18/18	1/18/18	0.00	1.31	Spray Paint		9-89 38
240	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC14		APR 08 2018
242	Crosstubes	1 pcs	1/18/18	1/18/18	0.00	3.30	Crosstubes-1		APR 08 2018
244	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC5		38
246	SprayPaint	1 pcs	1/18/18	1/18/18	0.00	1.31	Spray Paint		APR 18 2018
248	SprayPaint	1 pcs	1/18/18	1/18/18	0.00	1.31	Spray Paint		APR 18 2018
250	QC	1 pcs	1/18/18	1/18/18	0.00	0.00	QC14		38
252	Crosstubes	1 pcs	1/19/18	1/19/18	0.00	3.30	Crosstubes-1		APR 22 2018
260	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC5		38
270	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging1-1		APR 22 2018
280	QC	1 pcs	1/19/18	1/19/18	0.00	0.00	QC4		Srd
285	DC	1 pcs	1/19/18	1/19/18	0.00	0.00	DC		APR 22 2018
290	Packaging	1 pcs	1/19/18	1/19/18	0.00	0.00	Packaging3-1	LG050	APR 22 2018
300	QC21-FG	1 Ea	1/19/18	1/19/18	0.00	0.00	QC21		APR 23 2018

Part Op 130 - Bend tube as per Dwg D119-796-241 using CNC bender program

Descriptions: 145 - 1- CUT TUBE AT HEIGHT ON FAI SHEET

150 - ***** ENSURE PROPER JIG POSITIONING *****

160 - ***IMMEDIATELY AFTER GRINDING***

180 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

190 - Ensure copy of NDT results attached to work order.

200 - *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Inspect for damage & ensure results are as per Dwg D119-796-241

230 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

240 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

Primer M138687

AEROSPACE
CART
Container No: S048541
Part: D119-796-241
Job No: 170328
Serial No/ Batch: S048541
Revision:
Inspector:

Unit Aerospace Ltd.
1210 Aberdeen Street
Hamilton, ON K6A 1K7
Canada
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www.aerospac.com

Date: 03/01/18

242 - Assemble as per dwg D119-796-241 and QSI 2- Install D5152-043 with proseal 890 on concave surface, 0.100" MIN thick as per dwg using DT10112 (identified right and left) 3- Install center support without bonbing. 4- Install Damper support and contact pads using proseal 890 per dwg and clamp in position. 138784 exp 9/18

244 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

246 - ***VERIFY BY _____ BATCH # TO MATCH W/O Primer 138687 Clear 138832

248 - ***VERIFY BY _____ BATCH # TO MATCH W/O Paint 138793

250 - ***VERIFY BY _____ BATCH # TO MATCH W/O _____

252 - 1- Re-install non fixed hardware per dwg ***Torque clamps on damper and contact pad to 80-100 IN-LBS.*** 2- Apply a file-seal of proseal 890 around damper supports and contact pads. DAS

260 - ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED AS PER DWG.*** 1- ATTACH A RED TAG TO CENTER SUPPORT THAT READS CENTER SUPPORT NOT FIXED THEN DATE AND STAMP IT. S. K. A. F. L. K.

285 - Photocopy bluefile and create labels as per PPP D119-796-241 chg 004 005 9-88

290 - Identify and pack for shipping as per PPP D119-796-241 on w/o 170330-A 138784 exp 12/18

5 see check

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation <u>5022965</u>	D119-796-241TRN	1	7	0	0
242-Crosstubes	CR3212-4-07 <u>M138333-10</u> <u>(17) 1 scrap</u>	1	210	0	0
	D2873-043 <u>5034892</u> <u>(4)</u>	4	1	0	0
252-Crosstubes	D5122-1 <u>F165637</u> <u>(1)</u>	1	12	0	0
	D5123-1 <u>F153232</u> <u>(6)</u>	6	277	0	0
	D5123-5 <u>F153235</u> <u>(2)</u>	2	222	0	0
	D5134-041 <u>5052448</u> <u>(1) 5001176</u>	1	14	0	0
<u>MS27039-108</u> <u>5020602 (2)</u>	D5134-042 <u>5001176</u> <u>(1) 5001453</u>	1	8	0	0
<u>NAS1149D0332J</u> <u>5020606 (4)</u>	D5136-1 <u>F165342</u> <u>(1)</u>	1	9	0	0
<u>MS21042L3</u> <u>5038764 (2)</u>	D5136-2 <u>F165737</u> <u>(1)</u>	1	9	0	0
	D5152-043 <u>5034266</u> <u>(2)</u>	2	14	0	0
	D5515-1 <u>5053280</u> <u>(2)</u>	2	6	0	0
	MS21920-25 <u>5024697 (4)</u> <u>5050048 (2)</u>	4	149	0	0
	MS21920-28 <u>5024479</u> <u>(2)</u>	2	112	0	0
270-Packaging	AN174-3A <u>5002774</u> <u>(2)</u>	2	68	0	0
	MS21042-4 <u>5045901</u> <u>(2)</u>	2	3	0	0
	NAS1149D0432J <u>F1137459-15</u> <u>(4)</u>	4	628	0	0

Part Specifications

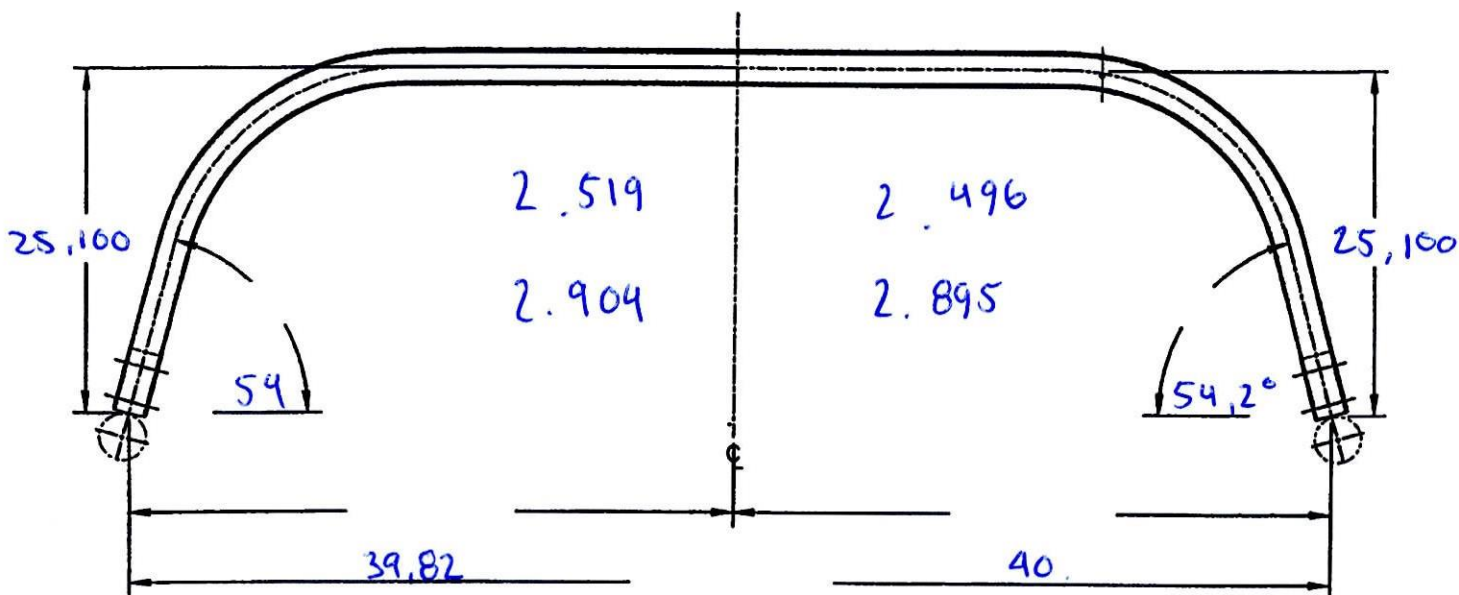
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
2	Crosstube Assembly (AW119 MKII Aft)	2.516Inches + 0.005 - 0.000	2.521 2.516		
3	Crosstube Assembly (AW119 MKII Aft)	2.626Inches + 0.005 - 0.000	2.631 2.626		
4	Crosstube Assembly (AW119 MKII Aft)	2.627Inches + 0.005 - 0.000	2.632 2.627		
5	Crosstube Assembly (AW119 MKII Aft)	2.798Inches + 0.005 - 0.000	2.803 2.798		
6	Crosstube Assembly (AW119 MKII Aft)	2.799Inches + 0.005 - 0.000	2.804 2.799		
7	Crosstube Assembly (AW119 MKII Aft)	2.989Inches + 0.005 - 0.000	2.994 2.989		
8	Crosstube Assembly (AW119 MKII Aft)	3.191Inches + 0.005 - 0.000	3.196 3.191		
9	Crosstube Assembly (AW119 MKII Aft)	3.200Inches + 0.005 - 0.000	3.205 3.200		
10	Crosstube Assembly (AW119 MKII Aft)	5.880Inches ± 0.030	5.910 5.850		
11	Crosstube Assembly (AW119 MKII Aft)	2.516Inches + 0.005 - 0.000	2.521 2.516		
12	Crosstube Assembly (AW119 MKII Aft)	2.626Inches + 0.005 - 0.000	2.631 2.626		
13	Crosstube Assembly (AW119 MKII Aft)	2.627Inches + 0.005 - 0.000	2.632 2.627		
14	Crosstube Assembly (AW119 MKII Aft)	2.798Inches + 0.005 - 0.000	2.803 2.798		
15	Crosstube Assembly (AW119 MKII Aft)	2.799Inches + 0.005 - 0.000	2.804 2.799		

16	Crosstube Assembly (AW119 MKII Aft)	2.989Inches	+ 0.005	2.994
			- 0.000	2.989
17	Crosstube Assembly (AW119 MKII Aft)	3.191Inches	+ 0.005	3.196
			- 0.000	3.191
18	Crosstube Assembly (AW119 MKII Aft)	3.200Inches	+ 0.005	3.205
			- 0.000	3.200
19	Crosstube Assembly (AW119 MKII Aft)	105.710Inches	± 0.020	105.730
				105.690

Plex 1/15/18 9:50 AM Dart.lajeunesse.marie

DART AEROSPACE LTD	Work Order: 170328
Description: Crosstube Aft, with Step	Part Number: D119-796-241
Inspection Dwg: D119-796-241 Rev: J	Page 1 of 1

Required Dimension	Min	Max
Height	24.840	25.100
1/2 Span	39.810	40.070
Angle	54°	57°
Total Span	79.620	80.140
Bending Passes	8	--
Crushing	--	8.5%

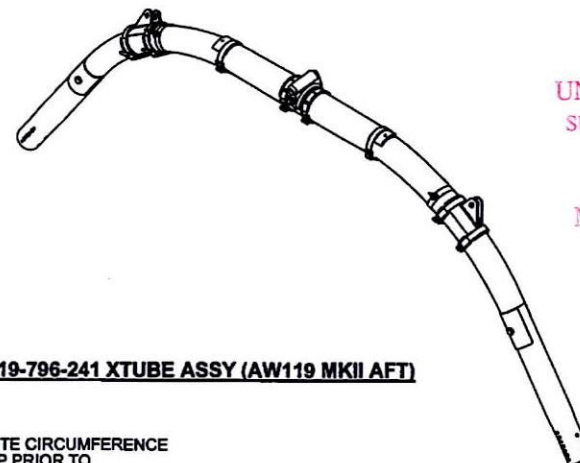


	Side A	Side B
Bending Passes	12	12
Crushing	7.1%	7.3%
Comments		

QC15 Inspection	DAS 38 9-88
Date	MAR 07 2018

Rev	Date	Change	Revised by	Approved
A	15.04.14	New Issue	KJ	
B	15.11.12	Min angle revised	KJ	
C	15.12.15	Dwg Rev updated	KJ	
D	17.07.12	Dwg Rev updated	KJ	

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170328 MLO
1801-15



D119-796-241 XTUBE ASSY (AW119 MKII AFT)

NOTES:

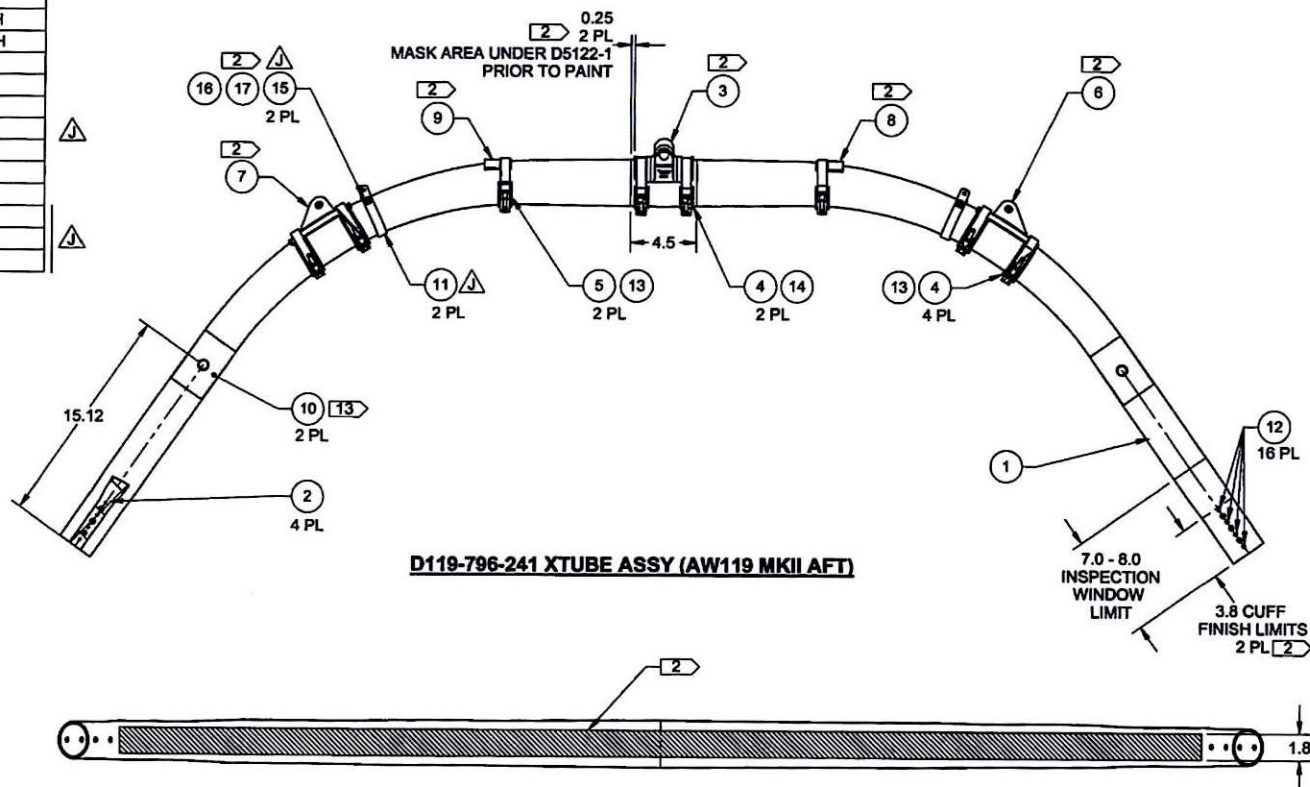
- 1) MATERIAL: N/A
- 2) FINISH: MASK D5134-041/042 DAMPER SUPPORT ASSEMBLIES, CUFFS, D5136-1/2 CONTACT PADS, THE COMPLETE CIRCUMFERENCE OF THE TUBE UNDER THE D5122-1 CENTER SUPPORT AND THE TAB ON THE D5515-1 GROUNDING CLAMP PRIOR TO APPLICATION OF CLEAR COAT/PAINT.
IF NECESSARY TOUCH UP PRIMER ON OUTSIDE OF CROSSTUBE PER DART QSI 005 4.2.
APPLY MATTE CLEAR COAT TO THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA) PER QSI 005 4.2.
MASK THE UNDERSIDE OF CROSSTUBE AS SHOWN (B4-2, HATCHED AREA).
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY USING PART NUMBER "D119-796-241" AND BATCH NUMBER ON INSIDE OF CUFF PER QSI 044 6.4
- 7) WEIGHT: 28.26 lbs
- 8) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE.
THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM DEFECTS SUCH AS SCRATCHES, NICKS OR DENTS. DEFECTS UP TO 0.005 MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 9) INSTALL D5122-1 CENTER SUPPORT HAND TIGHT ONLY. DO NOT TORQUE. INSTALL RED TAG TO INDICATE "D5122-1 CENTER SUPPORT MUST BE BONDED PER IIN-D119-796 PRIOR TO FLIGHT".
- 10) PRIOR TO FINISHING, ABRASE MATING SURFACES OF D5136-1/2 AND SURFACE OF CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5136-1/2 CONTACT PADS AND INSTALL AT AN 8.4" OFFSET FROM THE CROSSTUBE BENDING PLANE. INSTALL MS21920-25 CLAMPS AND D5123-5 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.
- 11) TORQUE MS21920 CLAMPS 80 - 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY. THE NUT HAS NOT BOTTOMED-OUT AFTER TORQUING AND THE NUT IS FACING AFT.
- 12) PRIOR TO FINISHING, POSITION AND INSTALL D5134-041/042 DAMPER SUPPORTS USING JIG DT10085. ABRASE MATING SURFACES OF THE D5134-041/042 DAMPER SUPPORTS AND CROSSTUBE WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. APPLY A 0.100" MIN THK LAYER OF PROSEAL 890 ON THE INSIDE CONCAVE SURFACE OF THE D5134-041/042. INSTALL MS21920-25 CLAMPS AND D5123-1 CLAMP CUSHIONS WHILE WET. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS. ENSURE THAT THE MS21920 CLAMPS ARE POSITIONED AS SHOWN IN DETAIL C.
- 13) PRIOR TO FINISHING, ABRASE MATING SURFACES OF CROSSTUBE AND D5152-043 WITH SCOTCH BRITE 7447 RED AND REMOVE RESIDUE WITH DUPONT 4105S WASH 'N' WIPE DEGREASER. INSTALL D5152-043 WITH LAYER OF PROSEAL 890 ON INSIDE CONCAVE SURFACE. 0.100" MIN THK LOCATE D5152-043 USING TOOL DT10112.
- 14) INSTALL THE D5515-1 GROUNDING CLAMP AND ASSOCIATED HARDWARE PER DETAIL "C" PRIOR TO FINISHING. TORQUE THE MS21042-3 NUT 12-15 IN-LB. COMPLETELY SEAL THE EDGES OF THE CLAMP USING PROSEAL 890.
- 15) CARRY OUT A RESISTANCE CHECK BETWEEN THE D5515-1 GROUNDING CLAMP AND ANY UNPAINTED SECTION OF THE CROSSTUBE IN ACCORDANCE WITH AC43-13-1B CHAPTER 11. MAXIMUM RESISTANCE IS 3 MEGOHMS.

RELEASED
2017-05-04
ECN 17-536

J	ADD NOTE 14 & 15 ON SHT 1. ADD PAINT/PRIMER MASKING LOCATIONS, REVISE NOTES ON SHT 1 & 4. REVISE BOM ON SHT 2 TO ADD GROUNDING CLAMP AND ASSOCIATED HARDWARE. REF PAR 17-680	ML	17.02.10
I	D6023-106 MATERIAL REPLACES D6009-106. D5136-1/2 & D5134-041/042 NOW INSTALLED ON PRIMER.	AP	15.10.13
H	NOTE 9 RE-WRITTEN. BONDING INSTRUCTIONS MOVED TO IIN. SEE PREVIOUS REV FOR DETAILS.	AP	15.07.02
G	FINISHING ORDER ADJUSTED. UPDATE BEND TOLERANCE AND TRN DETAIL TOLERANCE TO MATCH D119-796-141 DWG	AP	15.04.24
F	REMOVED PRIMER/PAINT ON CUFFS. 2.516 WAS 2.500 (C8-5)	AP	15.02.03
E	D5152-043 WAS D5150-3. SCOTCH BRITE 7447 RED WAS 180 GRIT SANDPAPER	DB	15.01.15
D	ADD D5150-3 STEP POST (2X). MOVED INSPECTION WINDOW DETAIL TO SHT 1. MODIFIED NOTES ON SH 1 & 3	DB	14.11.25
C	CR3212-4-07 RIVETS WAS CR3212-4-05 RIVETS, RADIUS BLOCK WAS NUT PLATE ASSEMBLY (BOM). REMOVED 7.5 DEG CUFF HOLE OFFSET (A1-3). REDUCED CUFF DIA TO 2.500 (C8-5). ADD INSPECTION WINDOW	AP	14.10.23
B	ORIENTATION OF D5122-1 CENTER SUPPORT WAS CORRECTED. D5123-5 ADDED UNDER D5136-1/2 CONTACT PADS. ADDED D2873-043 NUT PLATE ASSY & CR3212-4-05 RIVETS. ADDED REFERENCE TO SKIDTUBES FOR LOCATING CUFF HOLES. RE-ORGANIZED NOTES. REMOVED REDUNDANT INFORMATION.	AP	14.09.08
A	NEW ISSUE	AP	14.08.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-796-241	SHEET 1 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
DATE	17.02.10	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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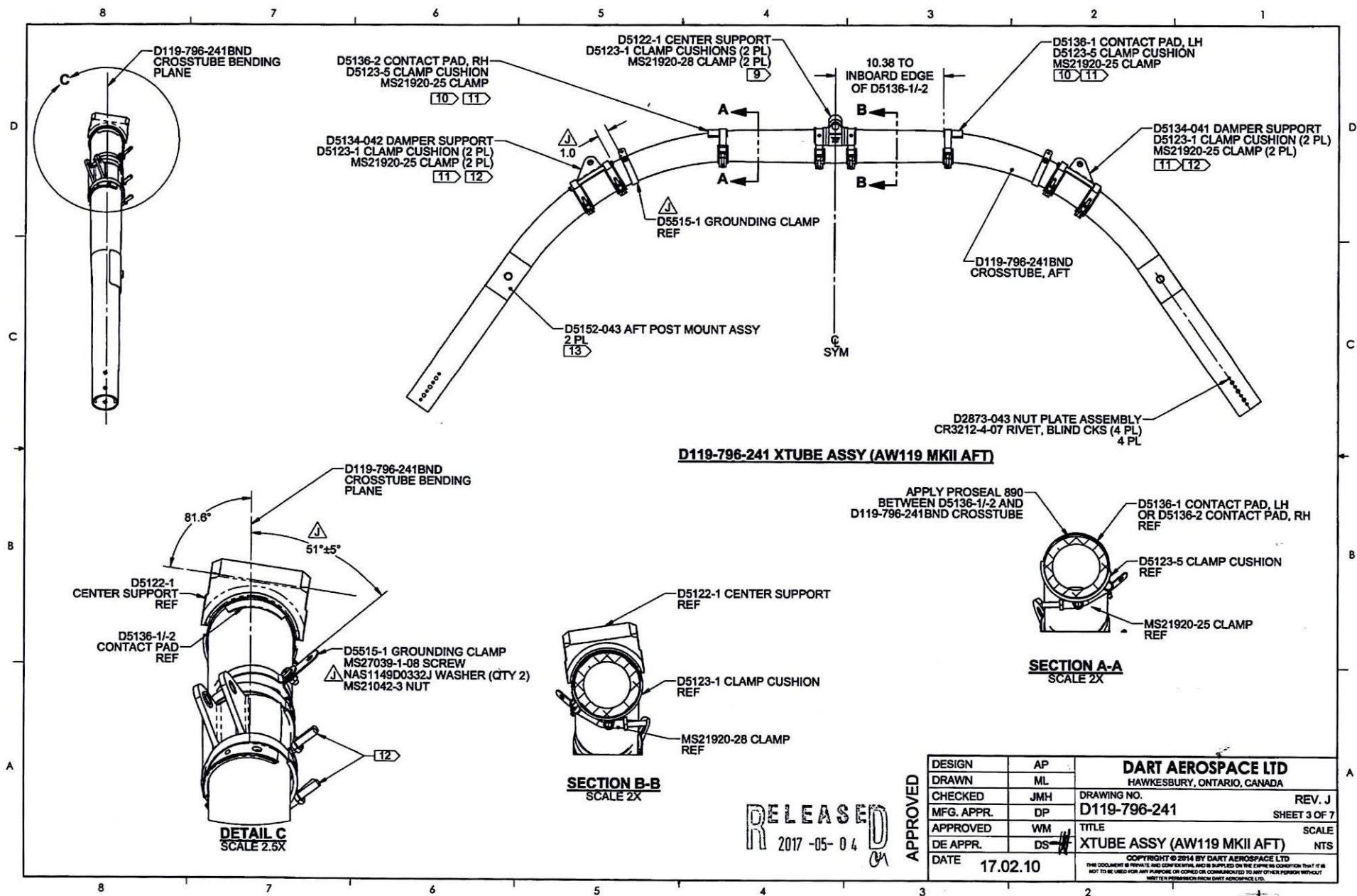
ITEM	QTY	P/N	DESCRIPTION
	X	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241BND	CROSSTUBE, AFT
2	4	D2873-043	RADIUS BLOCK
3	1	D5122-1	CENTER SUPPORT
4	6	D5123-1	CLAMP CUSHION
5	2	D5123-5	CLAMP CUSHION
6	1	D5134-041	DAMPER SUPPORT ASSY, LH
7	1	D5134-042	DAMPER SUPPORT ASSY, RH
8	1	D5136-1	CONTACT PAD, LH
9	1	D5136-2	CONTACT PAD, RH
10	2	D5152-043	AFT POST MOUNT ASSY
11	2	D5515-1	GROUNDING CLAMP
12	16	CR3212-4-07	CSK RIVET, CHERRY MAX
13	6	MS21920-25	CLAMP
14	2	MS21920-28	CLAMP
15	2	MS27039-1-08	SCREW, PAN-HEAD
16	2	MS21042-3	NUT
17	4	NAS1149D0332J	WASHER

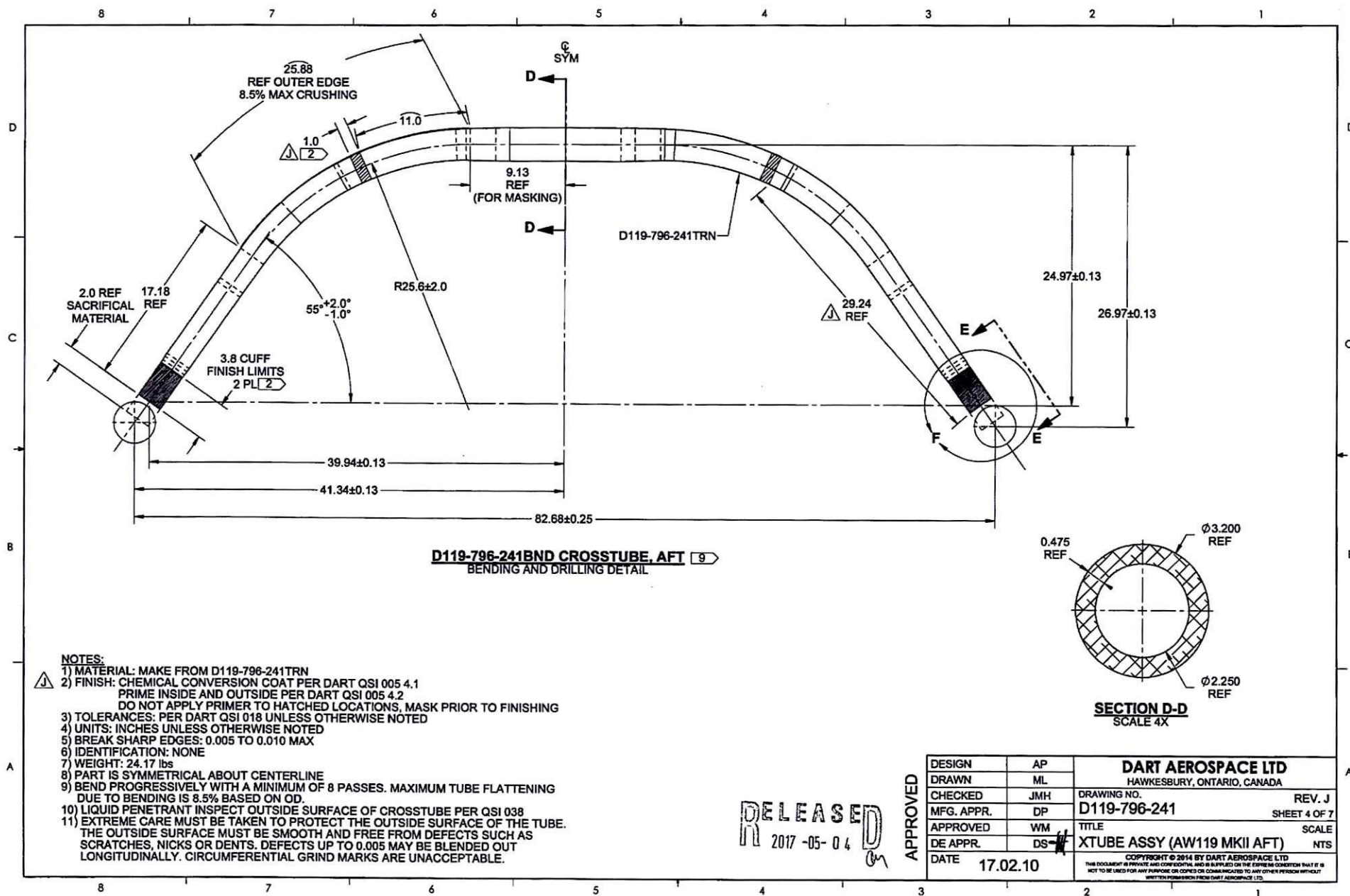


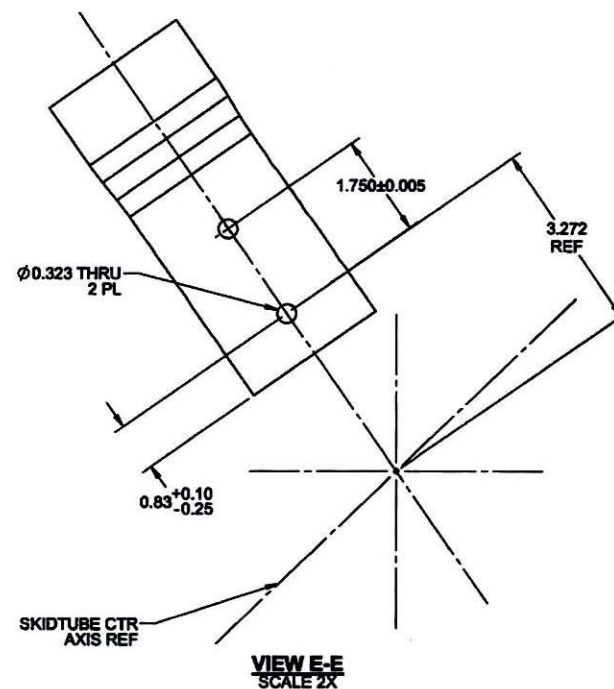
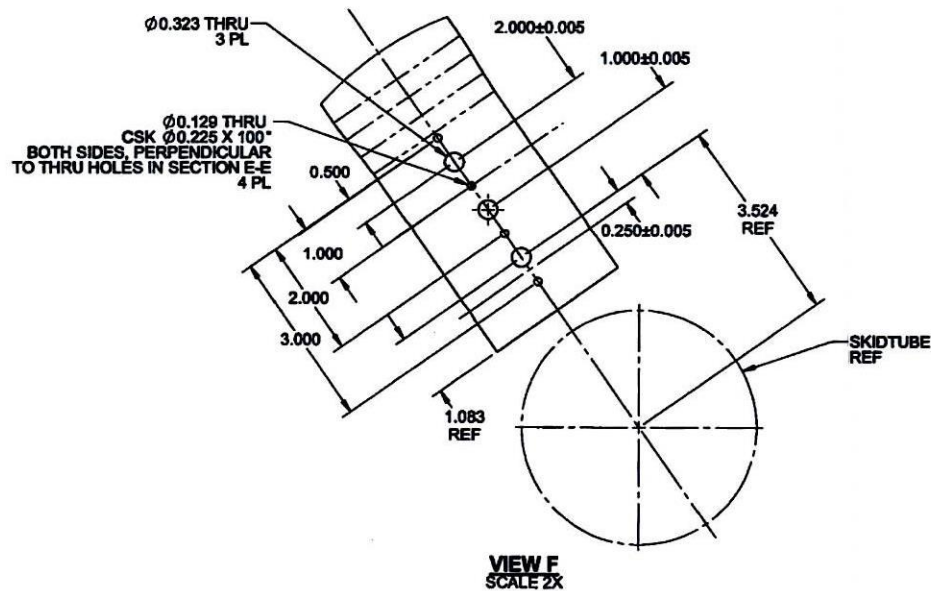
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CHECKED	JMH		
MFG. APPR.	DP		
APPROVED	WM		
DE APPR.	DS		
DATE	17.02.10		



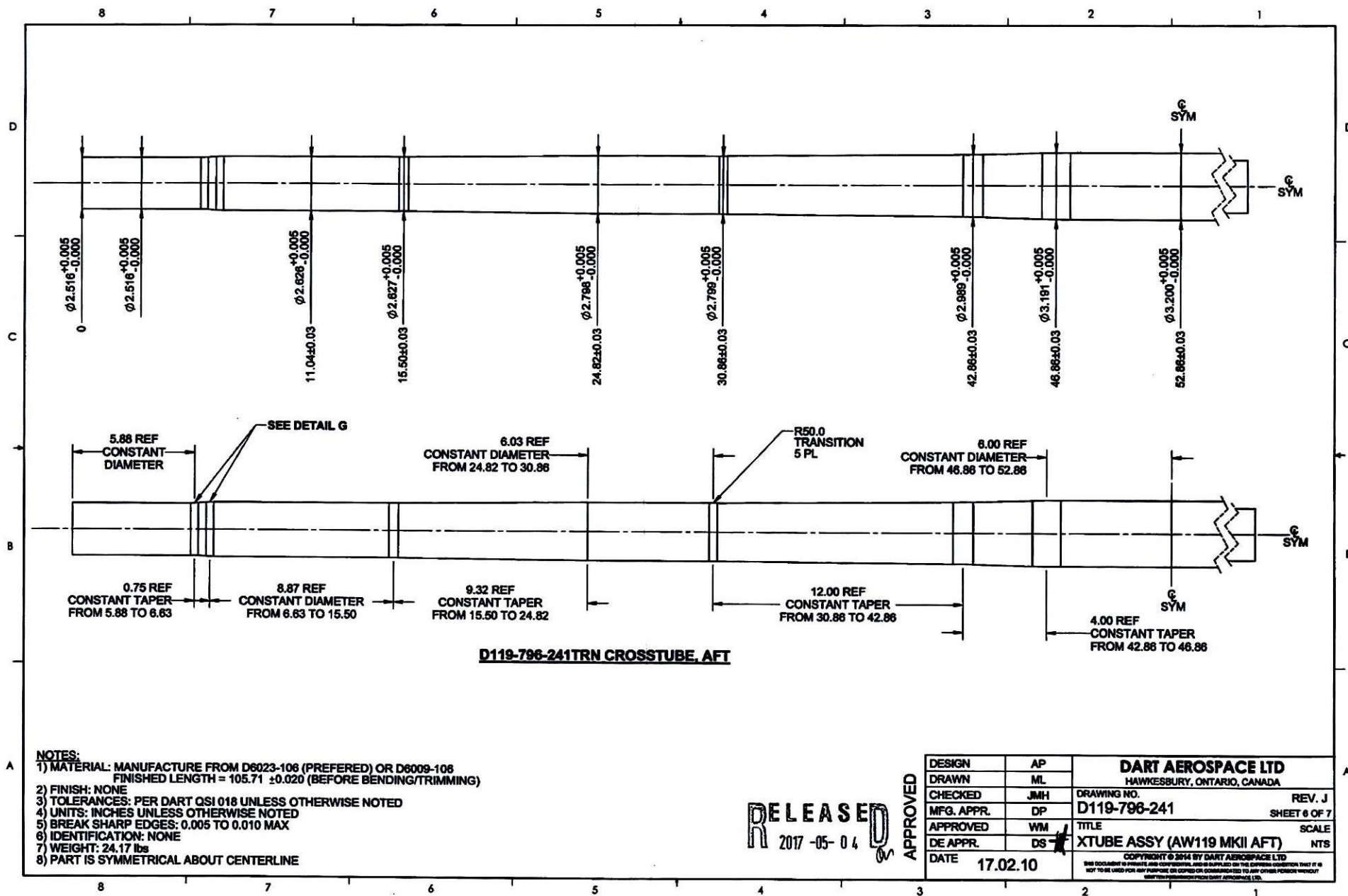


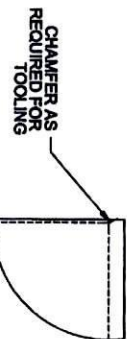


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 2017-05-04

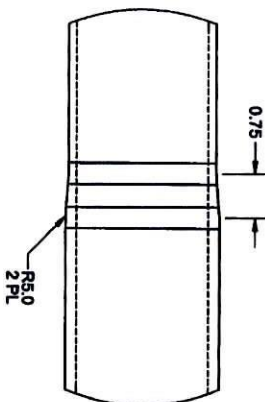
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CHECKED	JMH	DRAWING NO.	REV. J
MFG. APPR.	DP	D119-798-241	SHEET 5 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT)	NTS
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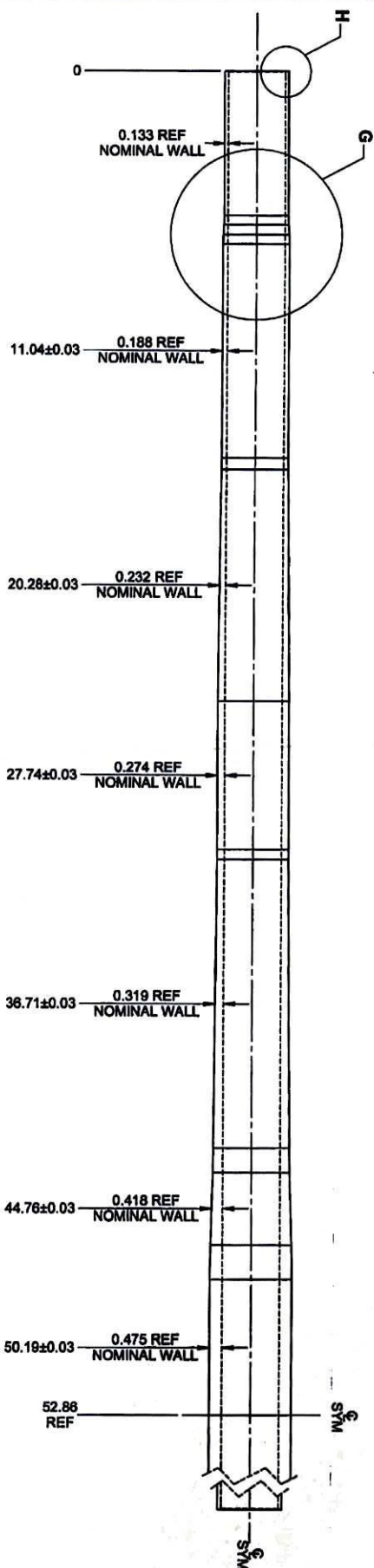




DETAIL H
SCALE 1X



DETAIL G
SCALE 2X



D119-798-241 TRN CROSS TUBE, AFT
SUPPLEMENTAL VIEW: NOMINAL WALL THICKNESS

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2017-05-04
APPROVED

DESIGN	AP	DART AEROSPACE LTD
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA
CHECKED	JMH	DRAWING NO.
MFG. APPR.	DP	D119-798-241
APPROVED	WM	TITLE
DATE	DS	XTUBE ASSY (AW119 MKII AFT)
17/02/10		SCALE
		NTS

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO039316

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO039316

PO Date: 3/14/18

Due Date: 3/15/18

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	171230	D119-796-141	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	3/15/18	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	171232			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
	171243			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:						3	0	3		\$395.63
2	170326	D119-796-241	Aft Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***	Firmed	3/15/18	1 pcs	0 pcs	1 pcs	\$131.875/pcs	\$131.88
	170327			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
	170328			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
	170329			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
	173744			Firmed	3/15/18	1 pcs	1x 0 pcs	1 pcs	\$131.875/pcs	\$131.88
Sub Total:						5	0	5		\$659.38

Grand Total: \$1,055.00

Order Notes

reid AT 18/03/15

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO35296	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: PO039316
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

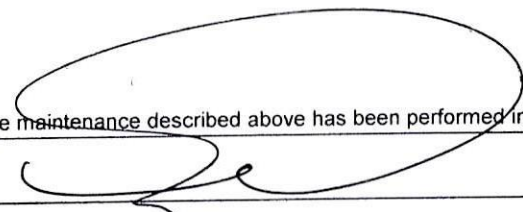
CARRY OUT NDT ON 8 CROSSTUBES AS PER PO039316

5 AFT CROSSTUBES, P/N# D119-796-241 , J/S# 170326 , 170327 , 170328 , 170329 , 173744

3 FWD CROSSTUBES , P/N# D119-796-141 , J/S# 171230 , 171232 , 171243

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13 ***NO CRACK FOUND*** PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , DEV. MPO11715 , UV LIGHT M-20142						MAR 14 2018	 
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: MAR 14 2018
Name: RAFIK MELIKIAN		

Change Record

PAGE 1 OF 1

Part Number: D119-796-241

Description: CROSSTUBE INSTALLATION, AFT STD, W/O PEG STEPS

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :					
Misidentified ☐	Past Due ☐						